

Ship Aug 14

Work Order ID 105591

105591

Page 1

Item ID: D2703

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Leg Clevis

Start Date: 8/08/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/09/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *V*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2703

Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.45" long

N/A G. J.

5 0
14 0
Ac
13.08.11

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per photo D27031 tumble and deburr any rough edges after tumbling

PROG REV.
Dwg Rev

5 0
14 0
Ac
13.08.11

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

PTO
D

QC2 Second Check 13.8.13

14

100

100

100

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Item ID: D2703 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Leg Clevis
 Start Date: 8/08/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/09/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3 Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: _____ FINISH TIME: _____ OVEN TEMPERATURE: _____
 3200F 7:40

W126125

5 NG13-815

SX M-13/08/16

SX M-13/08/16

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Item ID: D2703 Accept *N900040100* Setup Start *NS1*
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 Item Name: Leg Clevis
 Start Date: 8/08/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/09/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: (1x) STOCK								
170									
Packaging	Memo 3x PPP 105512	0.00							
Packaging	2x PPP 105513								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

5x 11/03/09/16

5x 11/13-08-16

13/8/2008

MW 13-08-16

Picklist Print

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Page 1

Work Order ID: 105591

Parent Item: D2703

Parent Item Name: Leg Clevis

Start Date: 8/08/13

Required Date: 8/09/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No				sf	107.3500		0.08	28	8/13/08/11	
6061T6 SHEET .250													

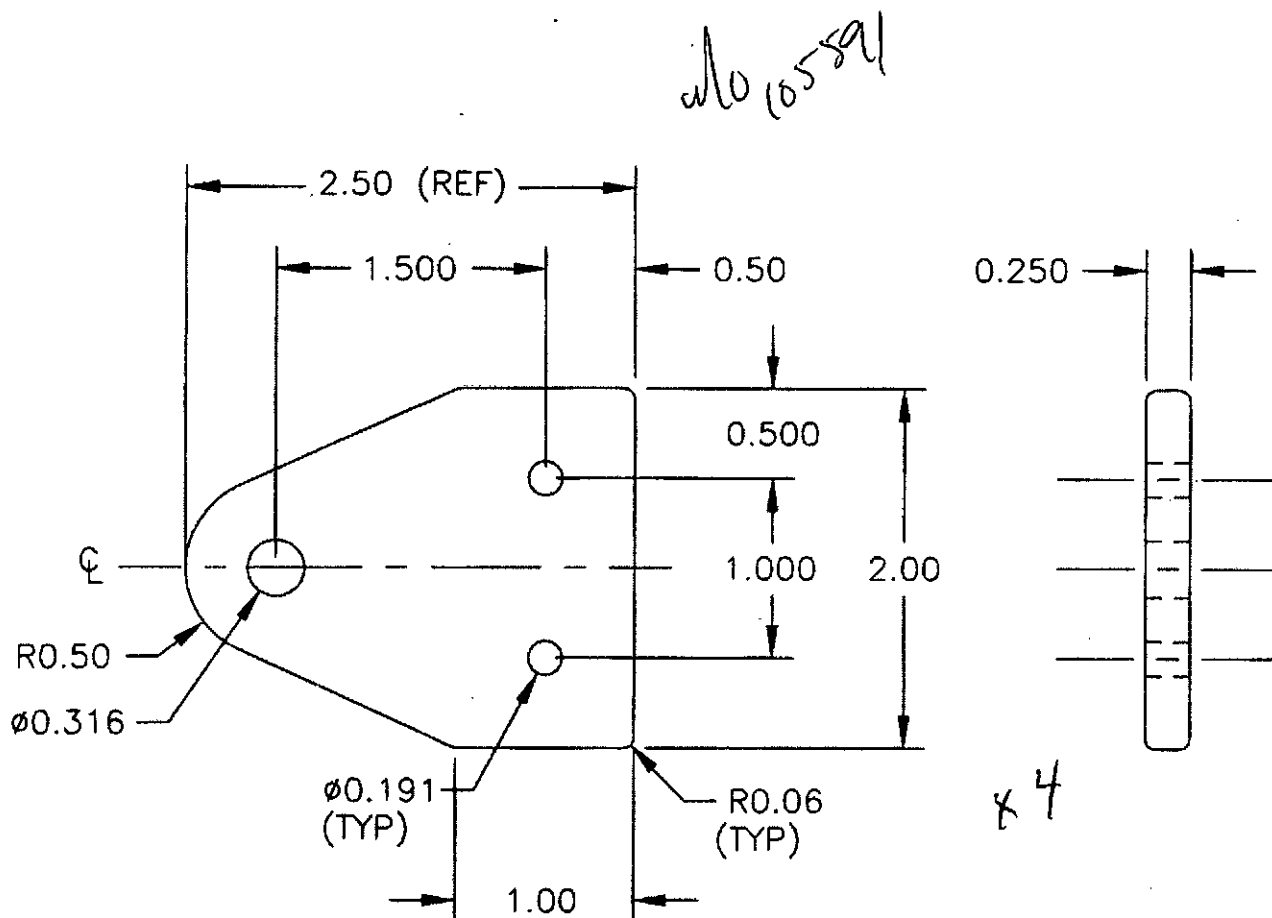
Location	Loc Qty	Loc Code
MAT021	107.35	
116808	23.8	
121194	26.3	
125024	57.25	

125024

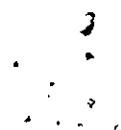


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2703	REV. B SHEET 1 OF 1
DATE 99.10.20		TITLE STA 84 LEG CLEVIS	SCALE 1:1
A	97.09.10	NEW ISSUE	
B	99.10.20	UPDATE TOLERANCE AND FINISH	

RELEASED
99.11.02 *KE*



NOTE: DEBURR ALL EDGES R0.030-R0.060
PART IS SYMMETRIC ABOUT CENTERLINE
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8
OR QQ-A-200/8 OR QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: SWH Date: 13/08/21QA Closed: SWH Date: 13/08/21

Work Order: <u>105591</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2703</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2967</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	13/8/13	100		$\phi 0.191$ holes are oversized from waterjet up to $\phi 0.205$ ", tapered.	<u>UP</u> 13/8/13	Acceptable. Ensure there are no ridges from waterjet, Remove if necessary	<u>As</u> 13.08.21	DAS 27 9-89 13.8.20	DAS 16 9-89 13/08/20
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio
	<input type="checkbox"/> Grain
	<input type="checkbox"/> Hardware
	<input type="checkbox"/> Inspection Incomplete
	<input type="checkbox"/> Instructions Incomplete/Unclear
	<input type="checkbox"/> Maintenance
	<input type="checkbox"/> Misabeled
	<input type="checkbox"/> Misread
	<input type="checkbox"/> Offset
	<input type="checkbox"/> Out of Calibration
	<input type="checkbox"/> Out of Sequence
	<input type="checkbox"/> Outside Dimensions
	<input type="checkbox"/> Ovalized
	<input type="checkbox"/> Over/Under tolerance
	<input type="checkbox"/> Part Incorrect
	<input type="checkbox"/> Part Lost/Missing
	<input type="checkbox"/> Part Moved
	<input type="checkbox"/> Positioned Wrong
	<input type="checkbox"/> Power Loss/Surge
	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Weld
	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Other

20
10
100

20
10
100

2
1
1

